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	er ID 69904 4, 2011 12:57:40 PM								Page 1
	D3488-042		Accept				Setup Stai	rt	
Revision ID: Item Name:	Blade Fitting Assembly, RH						Sto		
Start Date: Required Date: Reference:	5/24/2011 Start Qty: 1 5/31/2011 Req'd Qty: 1			Cust Item ID: Customer:					
Approvals:	Process Plan:		Tooling: SPC (Y/N):	Date:		J	Run Stai		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Too	l# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								<del></del>
D3488	Rev B	FAI REU BID							
100 	DOOSAN LATHI <b>Mem</b> 1-Tur	3	0.00 0.00 FA627□2-Deburr	11. 6. 8	}	12	ø		
110 QC Quality Control	QC2- Inspect part	s off machine FAI/FAIB	0.00	(1 · <b>6</b> · 8	3	12	<b>ø</b>		· ———

120

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

and ulo 7/06

HAAS CNC vertical machine #1

1-Machine as per Folio FA627 & Dwg D3488□2-Deburr

W/O:			WO	RK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector
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				****					
Part No	<b>:</b>	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:		-	WORK ORDE	ER NON-CONFORM	MANCE (NC	₹)		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B Sign Date	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector
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#### Work Order ID 69904

Tuesday, May 24, 2011 12:57:40 PM



Page 2

Item ID:

D3488-042

5/24/2011

Accept

Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Blade Fitting Assembly, RH

**Start Qty: 12.00** 

Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Start Date:** 

	-2	1
Α	.pprovals:	. 🐣

**Required Date: 5/31/2011** 

Process Plan:

Date:\_\_\_\_\_

Tooling: SPC (Y/N):

Date:

Tool # Plan

Date:

Run Start

Stop



Sequence ID/ **Work Center ID** 

130

**Quality Control** 

Operation **Description** 

QC2- Inspect parts off machine FAI/FAIB

Date:

Memo

Set Up/ **Run Hours** 

0.00

or Lulo 7/04

Code

Accept **Qty** 

Reject **Qty** 

Reject Number Stamp

Insp.

140

OC

**Quality Control** 

OC8- Inspect parts - second check

Memo

0.00

D.A 11/07/06

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

12 \$ BR 11-7-11.

150

HandFinish Hand Finishing

	•									
W/O:			WO	RK ORDER CHANC	GES					
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposition	:	QA:	N/C CI	osed;		Date: _	· 
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DATE	STEP	Description of NC	ļ		ction B	0: 0	Verific	ation	Approval	Approval
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#### Work Order ID 69904

Tuesday, May 24, 2011 12:57:40 PM



Page 3

Item ID:

D3488-042

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Blade Fitting Assembly, RH

**Start Date:** 

5/24/2011

**Start Qty: 12.00** 

4

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Date:

Run

Start Stop



Date:

SPC (Y/N):

Set Up/

**Run Hours** 

**Tool ID** 

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

Powdercoat

160

Required Date: 5/31/2011

Description White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Operation

0.00

□OVEN TEMPERATURE:

Powder Coating

170

**Quality Control** 

QC3- Inspect Part Finish

Memo

0.00

0.00

12 g M 1104/12

180

HandFinish Hand Finishing HandFinishing

Memo

0.00

Install Inserts as per Dwg D3488

0.00

W/O:			WO	RK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng /	Approval QC Inspector
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Part No	·	PAR #:	Fault Categ	jory:	_ NCR: Yes I	No DQA:	Date: _	
	Re	esolution:	Disposition	ı:	_ QA: N/C Clo	sed:	Date: _	
NCR:		_	WORK ORDE	R NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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#### Work Order ID 69904

Tuesday, May 24, 2011 12:57:40 PM



Page 4

Item ID:

D3488-042

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Blade Fitting Assembly, RH

Start Date:

5/24/2011

Start Qty: 12.00

Req'd Qty: 12.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Required Date: 5/31/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

**Work Center ID** 

190

Quality Control

**Operation** Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

**Tool ID** 

0.00 8 moder

200

Packaging

Packaging

Identify as per dwg & Stock Location.

Memo

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 1/7/13 de)

W//O:	•			IODK ODDE	CHANCEC				<del></del>	
W/O:	<u> </u>		V	ORK ORDER	1 CHANGES			· T	A 1	
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	N	CR: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposit	ion:	G	A: N/C C	closed:		Date: _	
NCR:		W	ORK OR	DER NON-CO	NFORMANO	CE (NC	R)		-	
		Description of NC		Corrective Ac	tion Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action D	escription of Eng	Sign Date	&   Secti	on C	Chief Eng	QC Inspector
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#### **Picklist Print**

Tuesday, May 24, 2011 12:57:46 PM

Work Order ID: 69904

Parent Item:

D3488-042

Parent Item Name: Blade Fitting Assembly, RH



Start Date: 5/24/2011

Required Date: 5/31/2011

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

-		Doodan Zame			~								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No				Each	700.0000		48	Λ	<u> </u>	<u>.                                    </u>
INGLET				Location		Loc (	<u>Oty</u>	Loc Code		٠	M ((	07/1	2
				ST282			700				_		
					100896		100		_		_		
					111529		300				_		
					111581		300	1111	ナチ1コ _	-18	_		
D6103-003		Manufactured	No				Each	13.0000		12			
Round Billet Aluminum										25	11.	6.6	>

Round Billet, Aluminum

Loc Oty Loc Code Location 12 12 MAT043 68173

W/O:	•		W	ORK ORDER CHAN	IGES				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCI	R: Yes	No DQA:	Date: _	
	, R	esolution:	Disposition	on:	QA:	N/C CId	sed:	Date: _	
NCR:			WORK ORE	ER NON-CONFORM	MANCE	(NCR	)		<b></b>
DATE	STEP	Description of NC	<i>4</i> -,		ection B	0: 0	Verification	1 Approval	Approval
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DART AEROSPACE LTD	Work Order:	1,9904
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Lath	le Section		<u></u>	///
Ø2.150	+/-0.005	2.145			20.62	
Ø2.780	+/-0.005	2.780				
Ø3.125	+/-0.010	3. (25				
Ø3.346	+/-0.010	3.347		.,		· · · · · · · · · · · · · · · · · · ·
0.125 x 45°	+/-0.010 x +/-0.1°	1125 x45°				**************************************
8.000	+0.030/-0.000	8.010				,,
9.250	+/-0.010	7.250	/			
0.188	+/-0.010	.181				
R0.032	+/-0.010	.032				
R0.062	+/-0.010	,062				, , , , , , , , , , , , , , , , , , , ,
Ø0.297	+0.005/-0.001	, 300				-
Ø0.430	+/-0.010	. 433		· · · · · · · · · · · · · · · · · · ·		
0.100	+/-0.010	. 100				
0.125	+/-0.010	./30				
2.620	+/-0.010	2.617				
3.500	+/-0.010	3.500				······
1.005	+/-0.010	1.005		<del>-</del>		
Ø0.484	+0.005/-0.001	. 485				
1.180	+/-0.010	1.179				
3.150	+/-0.010	3./50				
3.070	+/-0.010	3.070				<del></del>
R0.063	+/-0.010	12.063				

W/O:			M	/ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		÷								
Part No		PAR #:	Fault Ca	tegory:	_ NC	R: Yes	No DQ	A:	Date: _	<u></u>
	R	esolution:	Disposit	ion:	_ QA	: N/C C	closed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE	E (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section	on B		Verifi	cation	Approval	Approval
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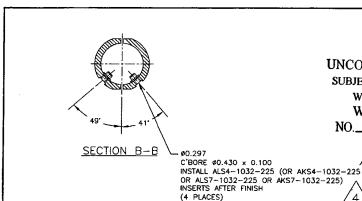
DART AEROSPACE LTD	Work Order:	1,9904
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Milli	ng Sectior	)		
Ø0.508	+0.006/-0.001	E. 509			bein 716	7
0.750	+/-0.010	.750	/		,1	
1.500	+/-0.010	1.500			1	
11.18	+/-0.030	11.182			Vern ext	-n2
R0.062	+/-0.010	R.062			R-G-	
0.125	+/-0.010	125			Vern Me	-2
0.590	+/-0.010	590			11	
0.793	+/-0.010	802			• (	111
1.351	+/-0.010	1.350	_		11	*******
1.317	+/-0.010	1.321			1(	
1.802	+/-0.010	1.803	_		"	
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Measured by:	and	Audited by:	B.A	Prototype Approval:	N/A
Date:	Notole	Date:	11107/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
В	08.09.19	Reformat P/O D3488-042	KJ/JLM LA	-1
С	08.12.02	Dimension 8.000 removed	KJ/JLM A	Jul 1

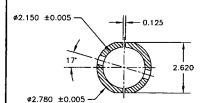
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·	PAR #:	Fault Ca	tegory:	_ NCF	R: Yes	No DQ	<b>\:</b>	Date:	1
Resolution:			Disposition: QA			A: N/C Closed:			Date:	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE	(NCR	)			
DATE	STEP	Description of NC	NC Corrective Action Section B				Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT

WITHOUT NOTICE

R0.062 (TYP) Ø0.508 (2 PLACES) R0.032 (TYP) R0.063 (TYP) 0.750 1.500 0.040 +0.000 8.000 +0.030



SECTION A-A

#### D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	Х	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	+	D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

#### D3488-041/-042 BLADE FITTING

MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR 1) MATERIAL:

PER QQ-A-225/9

(REF. DART MATERIAL SPEC M7075T73R)
ACID ETCH, ALODINE PER DART QSI 005 4.1

2) FINISH:

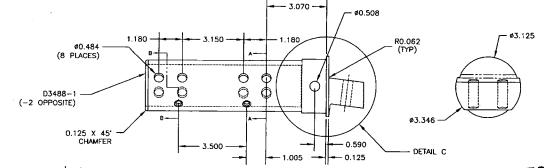
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

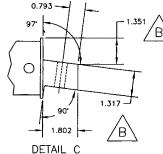
BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

INSTALL INSERTS AFTER POWDER COAT

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





D3488-041 SHOWN (D3488-042 OPPOSITE)

ECN # 789

В 06.03.15 CHANGE THICKNESS 05.12.20 NEW ISSUE DESIGN DART AEROSPACE USA, INC. PH DART 94 CHECKED D3488 SHEET 1 OF DATE TITLE SCALE 06.03.15

BLADE FITTING

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NOTE: Date & initial all entries

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